Work Order January 13, 2010												Page
Revision ID: Item Name: Ga	23566-1 asket 20/10	Start Qty: 12.00 Req'd Qty: 12.00			Cust Item I	IIIII IIII II			Setup	Start Stop		
Approvals: P	Process Plan	::_ <i>PD</i>	Date: 0-/-13	Tooling: SPC (Y/N):		ate:]	Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr										
D3566	Rev (<u> </u>	-									
100 Waterjet FLOW CNC Waterjet		FLOW WATER JET Memo 1-Cut as per l Deburr if nec	Dwg D3566 - ElDwg Revijessary	0.00 0.00 	. 2-			B	10-1-	-14	6	<u> </u>
110 QC Quality Control		QC2- Inspect parts off ma	chine FAI/FAIB	0.00				思	10~1-	-14		
120 		QC8- Inspect parts - secon	nd check	0.00	olochy			counter (+27	- - - - - - - - - - - - - - - - - - -	s		

Quality Control

Dart Aerospace Ltd

W/O:		AA A A A A A A A A A A A A A A A A A A	W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							-			
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _		
	R	esolution:	Dispositi	_ QA: N/C C	A: N/C Closed: Date:					
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NC	R)				
DATE	STEP	Description of NC	1 !a! _ 1	Corrective Action Section			cation	Approvai	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector	
									ļ	
								,		
								1		

Work Order ID 55320

Page 2

\ January 13, 2010 10:21:43 AM

Item ID:

D3566-1

Accept



Setup Start



Revision ID:

Item Name: Start Date:

Gasket

1/13/10

Start Qty: 12.00 Req'd Qty: 12.00

Date:

Cust Item ID:

Customer:

Reference:

Required Date: 1/20/10

Date:

Tooling:

Date:

Start

Stop

Approvals:

Process Plan:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

QC:

Identify as per dwg & Stock Location:_____

Memo

0.00 0.00

Draw Number Plan

Accept Code Qty

Reject Qty

Reject Number Stamp

Run

140

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/15 A MF 10-01-24

Dart A	erospa	ace Ltd
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W/O:			W	ORK ORDER CHANG	ES				7	
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval,	
				——————————————————————————————————————				Frod Migr		
										
Part No.	•	PAR #:	Fault Cat	egory:	NCP: Ves	No DO	۸٠	Date		
							osed: Date:			
								Date:		
NCR:			WORK ORL	DER NON-CONFORM	ANCE (NC	K)				
DATE	STEP	Description of NC		ion B	Verifi	cation	Approval	Approval		
OA:L	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		Section C	Chief Eng	QC Inspector	
		,								
		,								
	-					-				
								1		

Picklist Print

January 13, 2010 10:21:47 AM

Work Order ID: 55320

Parent Item:

Comments:

MNEO60S.063

D3566-1

Parent Item Name:

Gasket

IPP Rev:A

IPP Rev:B

New Issue 07-03-08 ec

Added Drain Holes 07-07-09 JLM

IPP Rev:C

As per Rev C 07-09-09 JLM Verified By:EC

Replacement Mfg/

Purchased

Bin Primary

No

Last

Route 100

Unit of sf

Qty on Remaining 831.4955 11.5074

Start Date: 1/13/10

Start Qty: 12.00

Qty 26, Date Status

Required Date: 1/20/10

Required Qty: 12.00

B10-1-14

NEOPRENE SHEET 0.063

Component Item ID/

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse				~
MAT	831.4955			(27)
112508	61.6034			()
112662	290.2821			
112866	154.11			
113058	325.5		113058	

Page 1

Dart	Aero	space	Ltd
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W/O:			WC	RK ORDER CHANG	ES			,
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector
								}
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	າ:	sed:	Date: _		
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)		
DATE	STED	Description of NC Corrective Action			on B	Verification	Approval	Approval
DAIL	SILP	TEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
I:								

DART AEROSPACE LTD	Work Order:	55520
Description: Gasket	Part Number:	D3566-1
Inspection Dwg: D3566 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3,105	0			
18.00	+/-0.030	18,00	`			
12.10	+/-0.030	01.61	×			
2.43	+/-0.030	2.433	Xo			
6.00	+/-0.030	6,000	Xe.			
1.40	+/-0.030	1.406	٧			
0.30	+/-0.030	,306	7			
0.30	+/-0.030	- 363	a			
0.063	+/-0.010	1661	7			
Ø0.188	+0.005/-0.001	.188	8			
						· · · · · · · · · · · · · · · · · · ·
						···

Measured by:	HR.	Audited by:	8	Prototype Approval:	N/A
Date:	10-1-14	Date:	10/01/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.14	New Issue	KJ/JLM	
В	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
С	07.09.26	Dwg Rev updated	KJ/EC/DD	6

SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 20.00 <u>&</u> NO 55 320 (REF) DETAIL A Ø0.19 (3 PLACES) DETAIL A Ø0.19 D D (4 PLACES) 3 10 2.43 ---38.50 18.00 EQUAL SPACES 3.10 3 FOUAL SPACES 5.50 PITCH 6.00 PITCH D3566-5 GASKET **D3566-1 GASKET** DETAIL A ◬ DETAIL A Ø0.19 1.25 - ပြ 2.43 ---3.10 Ø0.19 Ø0.19 (2 PLACES) B (2 PLACES) 3.50 -2.50 (REF) 23.50 1.40 EQUAL SPACES (REF) 5.88 PITCH 28.50 D3566-15 GASKET / **D3566-13 GASKET** D3566-7 GASKET В RELEASED 07.08.04 R0.11 UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES: CB 07.08.21 A8, B2: ADD D3566-15; 0.30 A5: INCREASE SIZE OF DETAIL A; 0.19 ADD DRAIN HOLES 07.04.17 Α **NEW ISSUE** PH 06,12,18 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER REV. DESCRIPTION DATE BY (REF DART SPEC M-NEO60-S.063) DESIGN DART AEROSPACE LTD 2) FINISH: NONE R0.38 DRAWN HAWKESBURY, ONTARIO, CANADA 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 0.30 CHECKED DRAWING NO. REV. C 4) UNITS: INCHES UNLESS OTHERWISE NOTED WEIGHTS: MFG. APPR D3566 SHEET 1 OF 1 5) BREAK SHARP EDGES: N/A 0.29 lbs D3566-1 DETAIL A APPROVED 6) IDENTIFICATION: NONE TITLE D3566-5 0.36 lbs SCALE SCALE 1:1 D3566-7 0.24 lbs 7) WEIGHT: SEE TABLE IN ZONE A3 GASKET DE APPR. D3566-13 0.07 lbs 8) PARTS ARE SYMMETRIC ABOUT & COPYRIGHT © 2006 BY DART AEROSPACE LTD

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Dart	Aero	spac	e Ltd

W/O:		WORK ORDER CH	IANGES				,
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE		Description of NC	Corrective Action Section B			Verification	Ammanal	Ammuousi
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector